

Work Order ID 83235

April-16-12 11:03:45 AM

83235

Page 1

Item ID: D205-706-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Purge Canister

Start Date: 16/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/16 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-706	Rev A								
100									
100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D205-706-013 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 16 12/10/22

MLJ 12-10-11

LX SP 12-10-11

DAS 16 12/10/22

FL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83235

83235

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM IPP Rev:F 10.05.10 as per
chg002 DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-5A		Purchased	No			110	Each	1,510.000					
--------	--	-----------	----	--	--	-----	------	-----------	--	--	--	--	--

AN3-5A
Bolt

**

m122800

SP SP

Location

Loc Qty

Loc Code

ST350

1510

115371

46

117423

124

118626

147

119355

200

120187

500

121185

493

AN814-6D

Purchased

No

110

Each

5.0000

AN814-6D
Plug

**

SP

SP

Location

Loc Qty

Loc Code

ST324

5

117946

5

AN815-6D

Purchased

No

110

Each

14.0000

AN815-6D
Union-M-Flare

**

m122807

12-10-12

Location

Loc Qty

Loc Code

ST325

14

119396

6

119433

2

119438

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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83235

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN833-6D Purchased No

110 Each 4.0000

AN833-6D

Elbow, Bulkhead-M-Flare

**

m121584 SP

Location

Loc Qty

Loc Code

ST328

4

119546

4

AN924-6D Purchased No

110 Each 12.0000

AN924-6D

Nut

**

m122814 SP

Location

Loc Qty

Loc Code

ST329

12

120693

12

AN960JD10 NAS1149D0363J Purchased No

110 Each 0.0000

AN960.ID10

Washer

**

m122378 SP

AN960JD10L NAS1149D0332J Purchased No

110 Each 0.0000

*AN960.ID10I *

Washer

**

m122973 SP

AN960JD916 NAS1149D0963J Purchased No

110 Each 0.0000

AN960.ID916

WASHER

**

m122452 SP

D2001-4 Manufactured No

110 Each 13.0000

D2001-4

Valve Assembly (1/4")

**

SP12-10-11

Location

Loc Qty

Loc Code

ST002

13

77058

3

77201

10

IX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 83235

83235

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3262-041

Manufactured No

110 Each

1.0000

D3262-041

Canister Assembly

**

B81547

Location

Loc Qty

Loc Code

ST198A

1

79828

1

D3264-1

Manufactured No

110 Each

3.0000

D3264-1

Bracket

**

B86029

Location

Loc Qty

Loc Code

ST198A

3

79348

3

D3297-1-0121

Manufactured No

110 Each

3.0000

D3297-1-0121

HOSE ASS'Y

**

SP

Location

Loc Qty

Loc Code

ST191

3

76200

3

D3297-1-0130

Manufactured No

110 Each

4.0000

D3297-1-0130

HOSE ASS'Y

**

SP 12-10-11

Location

Loc Qty

Loc Code

ST191

4

55069

1

76202

3

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 83235

83235

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3297-3-0350

Manufactured No

110

Each

2.0000

D3297-3-0350

HOSE ASS'Y

**

B82749 SP

Location

Loc Qty

Loc Code

ST192

2

47420

1

58005

1

D3298-001

Manufactured No

110

Each

9.0000

D3298-001

Tube Assembly

**

91745

Location

Loc Qty

Loc Code

ST192

9

47421

3

48507

6

D3298-009

Manufactured No

110

Each

3.0000

D3298-009

Tube Assembly

**

SP

Location

Loc Qty

Loc Code

ST192

3

47506

3

D3299-1

Manufactured No

110

Each

7.0000

D3299-1

Fitting

**

SP 12-10-11

Location

Loc Qty

Loc Code

ST037

7

42170

7

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 83235

83235

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3299-3

Manufactured No

110

Each

3.0000

D3299-3

Fitting

**

B82754 SP

Location

Loc Qty

Loc Code

ST037

3

75978

3

D3301-1

Manufactured No

110

Each

3.0000

D3301-1

Placard

**

B83161 SP

Location

Loc Qty

Loc Code

ST037

3

77598

3

D3301-3

Manufactured No

110

Each

16.0000

D3301-3

Placard

**

SP

Location

Loc Qty

Loc Code

ST037

16

77203

6

77856

10

D3302-1

Manufactured No

110

Each

1.0000

D3302-1

Doubler

**

B81921 SP

Location

Loc Qty

Loc Code

ST198

1

73094

1

D3302-3

Manufactured No

110

Each

0.0000

D3302-3

Doubler

**

B77594 SP

12-10-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 83235

83235

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,917.000

MS21042L3

Nut

**

M123265 SP

Location

Loc Qty

Loc Code

ST300

2917

117441

16

117885

32

118451

5

118927

3

119017

1697

119075

164

121349

1000

MS21919-WDG12

Purchased

No

110

Each

32.0000

MS21919-WDG12

Clamp

**

SP

Location

Loc Qty

Loc Code

ST307

32

107534

2

110985

30

MS21919-WDG16

Purchased

No

110

Each

5.0000

MS21919-WDG16

Clamp

**

M121584 1X SP

Location

Loc Qty

Loc Code

ST296

5

119546

5

MS21919-WDG9

Purchased

No

110

Each

200.0000

MS21919-WDG9

Clamp

**

SP 12-10-11

Location

Loc Qty

Loc Code

328

200

120986

200

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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April-16-12 11:03:50 AM

Work Order ID: 83235

83235

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21920-42

Purchased

No

110

Each

12.0000

MS21920-42

CLAMP(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

ST451

12

119659

8

119673

4

MS28778-6

Purchased

No

110

Each

17.0000

MS28778-6

Packing

Location

Loc Qty

Loc Code

FP002

2

118354

2

ST294

15

117591

15

MS35489-11

Purchased

No

110

Each

18.0000

MS35489-11

GROMMET

Location

Loc Qty

Loc Code

ST295

18

109166

8

119537

10

**

**

**

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
	2		D2026-101	SCREW
1	1	1	D3262-041	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
	1		D3297-1-0121	HOSE ASSEMBLY
	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0085	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
1	1		D3298-001	TUBE ASSEMBLY
1			D3298-003	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
1	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
1	1	1	D3299-1	FITTING
1	1		D3299-3	FITTING
1			D3299-5	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
4	4	4	AN3-5A	BOLT
1	1	1	AN814-6D	PLUG
3	2	2	AN815-6D	UNION
		1	AN816-6D	NIPPLE
1			AN832-6D	UNION
2	3	1	AN833-6D	ELBOW
		1	AN919-6D	REDUCER
5	4	1	AN924-6D	NUT
1			AN938-6D	TEE
4	4	2	AN960JD10L	WASHER
8	8	8	AN960JD10	WASHER

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Revision: A

Date: 04.11.30

2	2		AN960JD916	WASHER
4	4	4	MS21042L3	NUT
	1	1	MS21919WDG12	CLAMP
	2		MS21919WDG16	CLAMP
		2	MS21919WDG6	CLAMP
		3	MS21919WDG7	CLAMP
2	5		MS21919WDG9	CLAMP
2	2	2	MS21920-42	CLAMP
10	5	5	MS28778-6	O-RING
1	1	1	MS35489-11	GROMMET

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Revision: **A**

Date: 04.11.30